

Date: Monday, 12/11/2006 12:54:04 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 29848  
 Estimate Number : 11674  
 P.O. Number : WA  
 This Issue : 12/11/2006 S.O. No. : NA  
 Prsht Rev. : NC  
 First Issue : WA Type : MACHINED PARTS  
 Previous Run : 26919  
 Written By : WA  
 Checked & Approved By : WA 06/12/11  
 Comment : Est. B 98.12.07 Changed folio DM

Drawing Name : END CAP  
 Part Number : D28501  
 Drawing Number : D2850 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : WA  
 Due Date : 1/20/2007 Qty: 20 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2500X01500 6061-T6 Bar 2.5" x 1.5"



Comment: Qty.: 0.3368 f(s)/Unit Total : 6.7368 f(s)

6061-T6 Bar 2.5" x 1.5"

6061-T6 2.5" X 1.5"

Batch M9877

J.L 06/12/29

(20)

2.0 BAND SAW BAND SAW



Comment: Cut blanks: 3.8"

J.L 06/12/29

(20)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2850-1

Deburr and Tumble

J.L/J.F 06/12/30

(20)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L/J.F 06/12/30

(20)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

mk 07/01/02

(20)

6.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

P6 07/01/03

(20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: 29 Date: 8/18/18  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/11/2006 12:54:04 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 29848

Part Number: D28501

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

207.01.04

Job Completion



C207101104



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	29848
<b>Description:</b> High Float Step End Bracket		<b>Part Number:</b>	D2850-1
<b>Inspection Dwg:</b> D2850 <b>Rev:</b> A		<b>Page 1 of 1</b>	

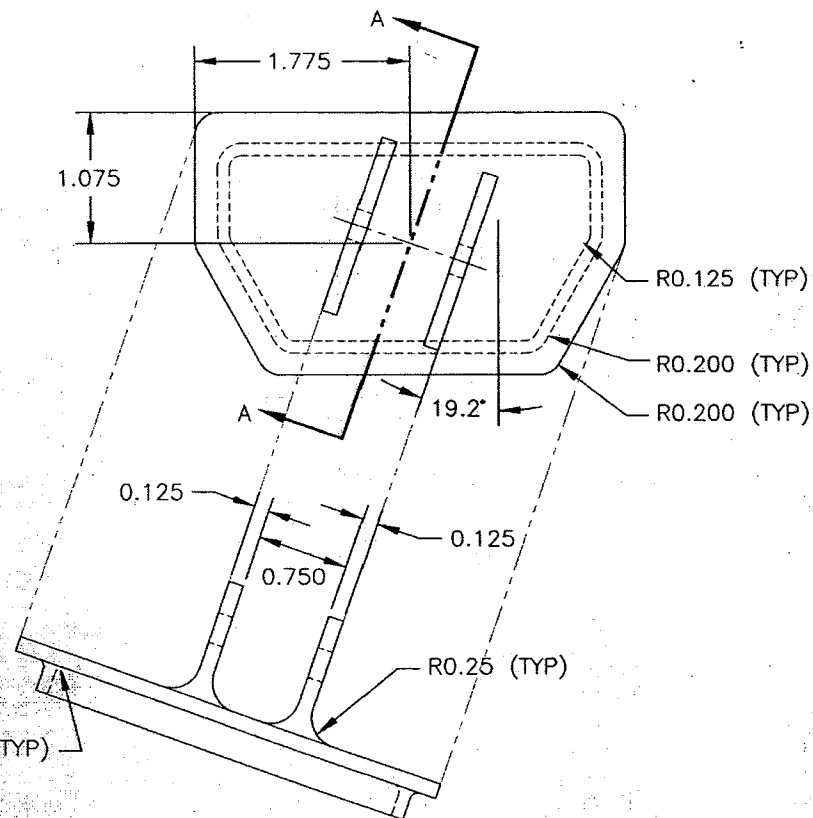
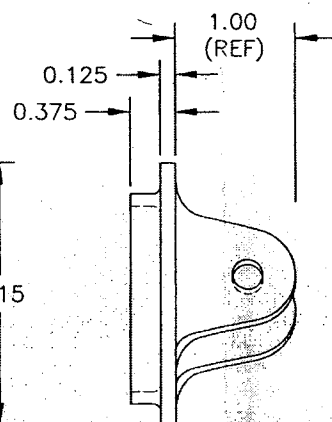
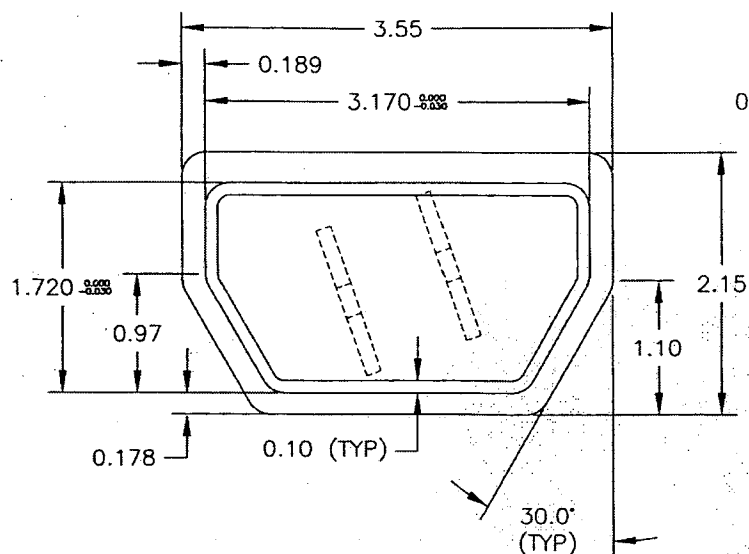
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.720	+0.000/-0.030	1.716	✓			
0.178	+/-0.010	.177	✓			
0.10	+/-0.030	.097	✓			
30.0°	+/-0.5°	30°	✓			
2.15	+/-0.030	2.152	✓			
0.375	+/-0.010	.377	✓			
0.125	+/-0.010	.125	✓			
1.00	+/-0.030	1.008	✓			
R0.125	+/-0.010	0.125	✓			
19.2°	+/-0.5°	19.2°	✓			
0.125	+/-0.010	.135	✓			
0.750	+/-0.010	.749	✓			
0.600	+/-0.010	.609	✓			

<b>Measured by:</b>	J.L	<b>Audited by:</b>	ml	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06/12/29	<b>Date:</b>	06/12/29	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	



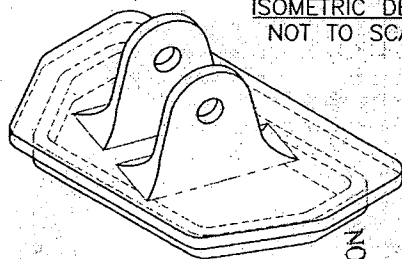
D2850-1 (SHOWN)  
D2850-2 (OPPOSITE)

MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)

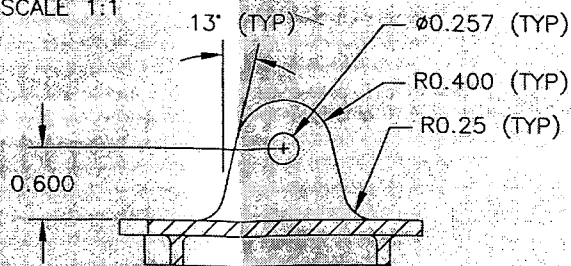
FINISH: NONE

BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

ISOMETRIC DETAIL  
NOT TO SCALE



SECTION A-A  
SCALE 1:1



RELEASED  
98.11.29

A	98.11.10	NEW ISSUE, REPLACES D2357 REV. A AND D2358 REV. B	
DESIGN	CL	DRAWN BY	CL
CHECKED	KE	APPROVED	#
DATE	98.11.10	DRAWING NO.	D2850
		TITLE	HIGH FLOAT STEP END BRACKET
		REV. A	SHEET 1 OF 1
		SCALE	1:1

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NO. 24848  
WORK ORDER  
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